

I claim

SUB A
1. A method of making a beverage container constructed from at least two
5 panels of flexible laminate web material, at least a first panel thereof having a
structural layer, a barrier layer and a sealant layer, said sealant layer having a first
thickness, comprising the steps of punching a hole through said first panel,
extruding molten sealant onto said sealant layer, thereby occluding said hole,
cooling said first panel and joining said panels to thereby form a drinking pouch.

1907
2. A method of making a beverage container as described in claim 1, wherein
said sealant layer is polyethylene in a first desired thickness and said extruded
molten sealant is extruded molten polyethylene.

15 3. A method of making a beverage container according to claim 1, including
the steps of conveying a bottom sheeting web in the conveying direction between
the front and rear side sheeting webs, and welding the bottom sheeting web in
part to the front and rear side sheeting webs.

20 4. A method of making a beverage container according to claim 2, including
the steps of conveying a bottom sheeting web in the conveying direction between
the front and rear side sheeting webs, and welding the bottom sheeting web in
part to the front and rear side sheeting webs.

5. A method of producing a beverage container made out of flexible laminate web material, comprising using a directed energy source to provide a puncture point on a surface of said web material at the intersection of at least two beam paths across said web material.

5

6. A method of producing a beverage container in accordance with claim 5, wherein said puncture point is formed by the intersection of at least three laser score paths.

10

7. A method of producing a beverage container in accordance with claim 6, wherein said intersection of laser score paths is provided against a highlighted background area on said web material.

15

8. A method of making a beverage container as described in claim 5, using a beam containing 3-4 times the energy used in normal scoring treatment.

20

9. A method of making a beverage container as described in claim 5, further comprising adjusting the energy and the speed of the laser beam to achieve the effect of a beam in the range of 2.5 joules to 3.5 joules.

10. A method of making a beverage container as described in claim 5, further comprising adjusting the laser beam energy by changing the distance between surface and said directed energy source.

25

11. A method of making a beverage container in accordance with claim 7, wherein said highlighted area is a dot.

12. A drinking bag container made out of flexible laminate web material having
5 a focal weakness comprising intersecting laser score paths, provided for insertion of a drinking straw.

13. A drinking bag container made out of flexible web material according to claim 12, wherein said intersection of laser score paths is provided in a highlighted
10 area on said web material.

14. A drinking bag container made out of flexible web material according to claim 12, having the width of the laser score paths 3-4 times wider than normal, thereby providing a larger focal weakness.

15. A drinking bag container made out of flexible web material according to claim 12, comprising a dot on the outer side of the front side of the bag, in order to enable a child to know where is the exact place which should be pierced by the
15 straw.

20 16. A method of making a beverage container comprising covering said holes by extrusion lamination of two layers, an adherence layer and an outer layer. The adherence layer is spread uniformly on to the sheet, thereby occluding the entire surface of the front side web including said holes. The other layer is placed onto

the adherence layer during the production process, using the adherence layer as an adhesive in order to stick the web together.

SUB 12
17. A method of making a beverage container as described in claim 16, in which
5 the final thickness of the web material is just the same as the thickness of a web without a hole, produced according to known methods. 112

12 73 7
10 18. A drinking bag container made from at least two panels of flexible laminate web material, at least one of said two panels of flexible laminate web material having a structural layer, and a barrier layer, said structural layer and said barrier layer having a hole passing therethrough and further having an extruded sealant layer applied onto said barrier layer and occluding said hole passing through said barrier layer and said structural layer.

15 19. A drinking bag container in accordance with claim 18, further comprising a sealant layer applied onto said extruded sealant layer.

20
Add 13